

**Work Order ID 79470****\*79470\***

Page 1

January-26-12 1:06:07 PM

Item ID: D2175-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Angle LH

Start Date: 26/01/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 09/02/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: M.C.J Date: 12/01/26

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2175

Rev E

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2175 Dwg Rev: E Prog Rev: E 2-  
Deburr if necessary

2009.063

B12-4-12

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

B12-4-12

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

5/12/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Setup Start \*NS1\*

Stop \*NS2\*

**Cust Item ID:**

**Customer:**

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

## Small Fab

### Small Fab

## Memo

0.00

## Small Fab

~~Deburr Stack~~

140

0.00

NC BRAKE

Brake NC

## Memo

0.00

Brake NC

Form as per Dwg D2175

150

QC5- Inspect part completeness to step on W/O

0.00

## Memo

QC

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 79470

\*79470\*


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January-26-12 1:06:08 PM

Item ID: D2175-1 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Angle LH  
 Start Date: 26/01/2012 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 09/02/2012 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				(5)	76	12-4-16	
170 *170* QC Quality Control	QC3- Inspect Part Finish QC Memo	0.00 0.00				5	0		12-4-16 P103
180 *180* Packaging Packaging	Identify as per dwg & Stock Location Memo	0.00 0.00				(5x)			SP 12-04-16

WIO: 79470		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/13	#170	change to QC7		2.04.17			S 12/13

Part No: D2175-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 4

January-26-12 1:06:08 PM

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Item Name: Angle LH

Start Date: 26/01/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 09/02/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

P12 04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

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Page 1

Work Order ID: 79470

\*79470\*

Parent Item: D2175-1

\*D2175-1\*

Parent Item Name: Angle LH

Start Date: 26/01/2012

Required Date: 09/02/2012

Start Qty: 4.00

Required Qty: 4.00

## Comments:

IPP E04.06.09ReformatKJ/RF

IPP Rev:F 06-04-28 Manufactured on Water Jet JLM

IPP Rev:G As per Rev E 06-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063

Purchased

No

100

sf

217.0000

0.4722

1.988211

2.5

\*M2024T3S 063\*

\*\*

B12-4-12

2024-T3 .063 sheet

## Location

## Loc Qty

## Loc Code

MAT022

217

117392

25

119916

192

119916

TS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	79470
<b>Description:</b> Angle		<b>Part Number:</b>	D2175-1/-2
<b>Inspection Dwg:</b> D2175 <b>Rev:</b> E		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.650	+/-0.010	12.650	2		T BO1	
R0.35	+/-0.030	.35	2		RG.	
2.915	+/-0.010	2.919	2		V BO2	
50°	+/-0.5°	50°	2			
0.300	+/-0.010	.306	2		V	
1.050 Pitch	+/-0.010	1.053	2		V	
10.500	+/-0.010	10.500	2		T	
11.550	+/-0.010	11.550	2		T	
0.550	+/-0.010	.550	2		V	
0.900	+/-0.010	.900	2		V	
0.063 thick	+/-0.010	.061	2		V	
Grain Direction	N/A		2			
Ø0.128	+0.005/-0.001	.128	2		V	
Ø0.172	+0.005/-0.001	.172	2		V	

<b>Measured by:</b>	B
<b>Date:</b>	12-4-12

<b>Audited by:</b>	S
<b>Date:</b>	12/04/13

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.03.23	Dimensions revised per Dwg rev. E	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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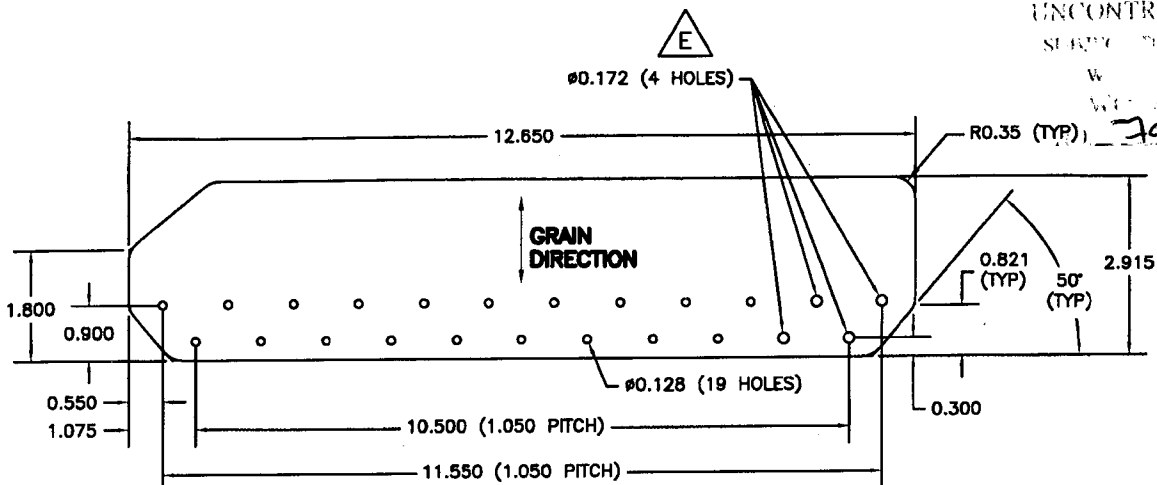
NOTE: Date & initial all entries

**DART**

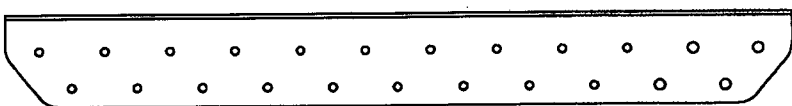
**RELEASED**  
26/09/25  
12/01/26

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SURVIVED TO WAREHOUSE  
W/OUT WORK ORDER

79470  
M.C.J.  
12/01/26



**D2175-1F FLAT PATTERN**



**D2175-1 BEND DETAIL SHOWN  
(D2175-2 BENT OPPOSITE)**

**NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN		DRAWN BY		DART AEROSPACE LTD	
RF		CE		HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	APPROVED	[Signature]	DRAWING NO.	REV. E
				D2175	SHEET 1 OF 1
DATE			TITLE	SCALE	
06.09.25			ANGLE	1:3	
A	95.10.25	NEW ISSUE			
B	96.01.18	CHANGED DIMENSION			
C	00.09.11	UPDATE FINISH SPEC			
D	04.06.03	RE-DESIGN			
E	06.09.25	INC HOLE DIA TO Ø0.172, 4 HOLES			

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